



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D206-642-541
Job Sheet 203168



Part No: D206-642-541

Job Qty: 1 pcs

Part Name: Repl.Skid.,High Gear,Std Wearplates Fits LH/RH, DART Tri-Bag Float Comp.



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/11/19

Job Tracking No:

Due Date: 12/6/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG D3274-041 REV G IPP Rev:F 08-06-02 add comment DD verified by:EC IPP Rev:G 08-10-09 revise details DD verified by:EC IPP Rev:H 13.09.05 CHG004/ ECN13-634 DD VERF:JLM IPP REV:I 14.04.28 AS PER ECN14-520 DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Skidtubes - 1	1 pcs	12/6/19		0.00	3.50	Skidtubes - 1		TF BR
							Skidtubes - 2		
							Skidtubes - 3		
							Skidtubes - 4		
							Skidtubes - 5		
							Skidtubes - 6		
							Skidtubes - 7		
114	QC 5	1 pcs	12/6/19		0.00	0.00	QC 5 - 10		DAS NOV 25 2019 68 9-89
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
116	QC 10	1 pcs	12/6/19		0.00	0.00	QC 10 - 10		
							QC 10 - 18		
							QC 10 - 24		
							QC 10 - 43		
							QC 10 - 81		



Container No: S234689



Part: D206 - 642 - 541

Job No: 203168

Serial No/Batch: S234689

Revision: G

Inspector:

Exp Date:

Instructions: FAA STC SA00475SE 18/11/19, JAL, STC SH98 -

Dart Aerospace Ltd.
1270 Aberdeen Street
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CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

120 Handfinish - 1-1 Chemical-B4B	1 pcs	12/6/19	0.00 0.68	QC 10 - 50				
				QC 10 - 58				
				QC 10 - 9	DAS			
				QC 10 - 68	NOV 25 2019 68 9-89			
				Handfinish - 1 - 1 - B4B				
				Handfinish - 1 - 2 - B4B				
				Handfinish - 1 - 3 - B4B	NOV 26 2019			
				Handfinish - 1 - 4 - B4B				
				Handfinish - 1 - 5 - B4B				
				Handfinish - 1 - 6 - B4B				
				Handfinish - 1 - 7 - B4B				
				Handfinish - 1 - 8 - B4B				
				Handfinish - 1 - 9 - B4B				
				Handfinish - 1 - 10 - B4B				
				Handfinish - 1 - 11 - B4B				
				Handfinish - 1 - 12 - B4B				
				Handfinish - 1 - 13 - B4B				
				Handfinish - 1 - 14 - B4B				
				Handfinish - 1 - 15 - B4B				
				Handfinish - 1 - 16 - B4B				
				Handfinish - 1 - 17 - B4B				
				Handfinish - 1 - 18 - B4B				
				Handfinish - 1 - 19 - B4B				
				Handfinish - 1 - 20 - B4B				
				Handfinish - 1 - 21 - B4B				
				Handfinish - 1 - 22 - B4B				
130 QC 7	1 pcs	12/6/19	0.00 0.00	QC 7 - 10				
				QC 7 - 13				
				QC 7 - 14				
				QC 7 - 15				
				QC 7 - 17				
				QC 7 - 18				
				QC 7 - 19				
				QC 7 - 2				
				QC 7 - 28				
				QC 7 - 3				
				QC 7 - 30				
				QC 7 - 34				
				QC 7 - 36				
				QC 7 - 37				
				QC 7 - 41				
				QC 7 - 47				
				QC 7 - 48				
				QC 7 - 51				
				QC 7 - 58				
				QC 7 - 59				
				QC 7 - 60				
				QC 7 - 9				
								Plex 11/11/19 2:00 PM Dart.lajeunesse.marie

					QC 7 - 68	
					QC 7 - 50	
					QC 7 - 67	
					QC 7 - 40	
					QC 7 - 24	
					QC 7 - 43	
					QC 7 - 61	
					QC 7 - 81	
					QC 7 - 76	
					QC 7 - 79	
150	Skidtubes - 2 - B4B	1 pcs	12/6/19	0.00 1.50	Skidtubes - 1 - B4B	
					Skidtubes - 2 - B4B	
					Skidtubes - 3 - B4B	MLG
					Skidtubes - 4 - B4B	
					Skidtubes - 5 - B4B	
					Skidtubes - 6 - B4B	
					Skidtubes - 7 - B4B	
160	QC 5	1 pcs	12/6/19	0.00 0.00	QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	BE
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
					QC 5 - 61	
					QC 5 - 81	
170	Skidtubes - 3 - B4B	1 pcs	12/6/19	0.00 2.17	Skidtubes - 1 - B4B	
					Skidtubes - 2 - B4B	
					Skidtubes - 3 - B4B	MLG MLG
					Skidtubes - 4 - B4B	
					Skidtubes - 5 - B4B	
					Skidtubes - 6 - B4B	
					Skidtubes - 7 - B4B	
180	QC 5	1 pcs	12/6/19	0.00 0.00	QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	BE
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	

190 Skidtubes - 4 - B4B	1 pcs	12/6/19	0.00 3.68	QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
				Skidtubes - 1 - B4B	
				Skidtubes - 2 - B4B	
				Skidtubes - 3 - B4B	MLG
				Skidtubes - 4 - B4B	BE
200 QC 5	1 pcs	12/6/19	0.00 0.00	Skidtubes - 5 - B4B	
				Skidtubes - 6 - B4B	
				Skidtubes - 7 - B4B	
				QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	DAS
				QC 5 - 68	DEC 04 2019 68
				QC 5 - 9	9-89
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
210 QC 10	1 pcs	12/6/19	0.00 0.00	QC 5 - 61	
				QC 5 - 81	
				QC 10 - 10	
				QC 10 - 18	
				QC 10 - 24	
				QC 10 - 43	
				QC 10 - 50	
				QC 10 - 58	
220 Handfinish - 2-1 Pressure- B4B	1 pcs	12/6/19	0.00 0.45	QC 10 - 9	DAS
				QC 10 - 68	DEC 04 2019 68
				Handfinish - 2 - 1 - B4B	9-89
				Handfinish - 2 - 2 - B4B	DEC 04 2019
230 Spray Paint - 2 - B4B	1 pcs	12/6/19	0.00 0.40	Handfinish - 2 - 3 - B4B	
				Handfinish - 2 - 4 - B4B	
				Spray Paint - 1 - B4B	
				Spray Paint - 2 - B4B	• RD 19-12-4
240 QC 14	1 pcs	12/6/19	0.00 0.00	Spray Paint - 3 - B4B	
				Spray Paint - 4 - B4B	
				QC 14 - 15	AL 19-12-5
				QC 14 - 2	
				QC 14 - 34	
				QC 14 - 41	
				QC 14 - 51	
				QC 14 - 58	
				QC 14 - 59	
				QC 14 - 9	
				QC 14 - 68	
				QC 14 - 40	
				QC 14 - 19	
				QC 14 - 43	
				QC 14 - 24	
				QC 14 - 61	

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244 Handfinish - 3-1- WingWalk-B4B	1 pcs	12/6/19	0.00 0.50	QC 14 - 81	
				Handfinish - 3 - 1 - B4B	14-12-5
				Handfinish - 3 - 2 - B4B	
				Handfinish - 3 - 3 - B4B	
				Handfinish - 3 - 4 - B4B	
				Handfinish - 3 - 5 - B4B	
246 QC 3	1 pcs	12/6/19	0.00 0.00	QC 3 - 10	
				QC 3 - 13	
				QC 3 - 15	
				QC 3 - 17	
				QC 3 - 18	
				QC 3 - 2	
				QC 3 - 28	
				QC 3 - 3	
				QC 3 - 30	
				QC 3 - 34	
				QC 3 - 36	
				QC 3 - 41	
				QC 3 - 51	
				QC 3 - 58	
				QC 3 - 59	14-12-05
				QC 3 - 68	
				QC 3 - 9	
				QC 3 - 40	
				QC 3 - 19	
				QC 3 - 43	
250 Handfinish - 4-1-Assembly-B4B	1 pcs	12/6/19	0.00 0.45	QC 3 - 24	
				QC 3 - 61	
				QC 3 - 81	
				Handfinish - 4 - 1 - B4B	14-12-5
				Handfinish - 4 - 10 - B4B	
				Handfinish - 4 - 11 - B4B	
				Handfinish - 4 - 12 - B4B	
				Handfinish - 4 - 13 - B4B	
				Handfinish - 4 - 14 - B4B	
				Handfinish - 4 - 15 - B4B	
				Handfinish - 4 - 2 - B4B	
				Handfinish - 4 - 3 - B4B	
				Handfinish - 4 - 4 - B4B	
				Handfinish - 4 - 5 - B4B	
				Handfinish - 4 - 6 - B4B	
				Handfinish - 4 - 7 - B4B	
260 QC 5	1 pcs	12/6/19	0.00 0.00	Handfinish - 4 - 8 - B4B	
				Handfinish - 4 - 9 - B4B	
				QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	

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						QC 5 - 51		
						QC 5 - 58		DAS
						QC 5 - 68	DEC 05 2019	68
						QC 5 - 9		9-89
						QC 5 - 50		
						QC 5 - 30		
						QC 5 - 40		
						QC 5 - 61		
						QC 5 - 81		
270	Handfinish - 4-2-Assembly-B4B	1 pcs	12/6/19	0.00	0.68	Handfinish - 4 - 1 - B4B		19-12-5
						Handfinish - 4 - 10 - B4B		
						Handfinish - 4 - 11 - B4B		
						Handfinish - 4 - 12 - B4B		
						Handfinish - 4 - 13 - B4B		
						Handfinish - 4 - 14 - B4B		
						Handfinish - 4 - 15 - B4B		
						Handfinish - 4 - 2 - B4B		
						Handfinish - 4 - 3 - B4B		
						Handfinish - 4 - 4 - B4B		
						Handfinish - 4 - 5 - B4B		
						Handfinish - 4 - 6 - B4B		
						Handfinish - 4 - 7 - B4B		
						Handfinish - 4 - 8 - B4B		
						Handfinish - 4 - 9 - B4B		
280	QC 5	1 pcs	12/6/19	0.00	0.00	QC 5 - 10		
						QC 5 - 12		
						QC 5 - 17		
						QC 5 - 18		
						QC 5 - 19		
						QC 5 - 22		
						QC 5 - 24		
						QC 5 - 3		
						QC 5 - 43		
						QC 5 - 49		
						QC 5 - 51		
						QC 5 - 58		DAS
						QC 5 - 68	DEC 06 2019	68
						QC 5 - 9		9-89
						QC 5 - 50		
						QC 5 - 30		
						QC 5 - 40		
						QC 5 - 61		
						QC 5 - 81		
290	Packaging 3-1 - Stock - B4B	1 pcs	12/6/19	0.00	0.00	Packaging 3 - 1 - B4B		
						Packaging 3 - 2 - B4B		
						Packaging 3 - 3 - B4B		
						Packaging 3 - 4 - B4B		
						Packaging 3 - 5 - B4B		
						Packaging 3 - 6 - B4B		
						Packaging 3 - 7 - B4B		
						Packaging 3 - 8 - B4B		
						Packaging 3 - 9 - B4B		
						Packaging 3 - 10 - B4B		
						Packaging 3 - 11 - B4B		
						Plex 11/11/19 2:00 PM Dart.lajeunesse.marie		

				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	DAS
				Packaging 3 - 25 - B4B	78 DEC 10 2019
				Packaging 3 - 26 - B4B	9-89
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	DAS
295 DC - 1 - B4B	1	12/6/19	0.00 0.00	DC - 1 - B4B	21 DEC 10 2019
	pcs			DC - 2 - B4B	9-89
300 QC 21 - FG	1	12/6/19	0.00 0.00	QC 21 - FG - 21	DAS DEC 10 2019
	pcs			QC 21 - FG - 70	21
				QC 21 - FG - 53	9-89

Part Op 110 - (Skidtubes) ****VERIFY AND INSPECT THE MATERIAL PRIOR TO USE**** 1- remove fwd indexing ridge as per Descriptions: dwg D3274. Prepare for welding 2- weld fwd cap as per dwg D3274 and QSI004 AR Aluminum Rod Batch: 38989/139019 3- grind fwd cap weld on top surface only 4- Cut AFT end of tube at 170.9" as per dwg D3274 and deburr end. 5-Drill Aft cap pilot hole using DT8025 6 -Cleco DT8025 in position and install pilot hole drill Jig DT8742A,B,C,D and DT8742. Drill 3/16" pilot holes as per Dwg D3274 7 -Remove inner indexing ridge on aft end of skidtube as per Dwg D3274 scribe batch # 8 -Open aft end cap holes to Ø0.208" as per Dwg D3274. Deburr aft end.

114 - (QC5- Inspect part completeness to step on W/O)
 116 - (QC10- Inspect visual per QSI004- ground welds)
 120 - (Chemical Conversion Coat per QSI005 4.1)
 130 - (QC7-Inspect Chemical Conversion Coat)
 150 - (Skidtubes) 1-Open Ø0.313" and 0.375" crossbolt spacer holes as per Dwg D3274 2-Deburr crossbolt spacer holes as per Dwg D3274 and blow out chips from inside the tube 3-Bond web in place as per Dwg D3274 & QSI 015. (Adhere for 12 hours) 5231095 exp 03-18-2020
 160 - (QC5- Inspect part completeness to step on W/O)
 170 - (Skidtubes) 1-Bend AFT end of tube using bend prog. D3274 AFT as per dwg D3274. Install drop pins in crossbolt spacer holes to maintain web position. 2- DRILL PILOT HOLES FOR WEARPLATES USING D3274-1T2 OPEN HOLES TO .297". Deburr 3-DRILL TOE PIN HOLE .640" DIA AS PER DWG USING DT8935 FWD END OF TUBE DEBURR INSIDE OF HOLE AS NECESSARY (DO NOT ENLARGE HOLES) REMOVE ANY FOREIGN OBJECTS INSIDE OF TUBES 4- Countersink crossbolt spacer holes as per Dwg D3274 5- prepare for welding
 180 - (QC5- Inspect part completeness to step on W/O) AK 38989
 190 - (Skidtubes) 1-Insert D2649 & D3275-1 crossbolt spacers. Weld as per QSI 004 and Dwg D3274. Remember to back drill each hole before welding the other side. Use aluminum rod 3-Grind cross bolt welds flush as per Dwg D3274. ****INSPECT FOR PIN HOLES IN WELD**** 4-Counterbore 5/16" x 0.750" deep as per Dwg D3274 and deburr.
 200 - (QC5- Inspect part completeness to step on W/O)
 210 - (QC10- Inspect visual per QSI004- ground welds)
 220 - (Pressure Wash per QSI005 4.3/ Clean and remove all markings) Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch
 230 - (Spray Paint / NDT Room) Make sure Nut Plate Thread is protected using paint screw. 1- PRIME AS PER DWG AND QSI 005 4.2 PRIMER PRG DESOTO 515X349 BATCH: 5231097 2- PAINT WHITE AS PER DWG AND QSI 005 4.2 PAINT BATCH: 5231092
 240 - (QC14- Inspect Spray Paint)
 244 - (Wing Walk as per dwg QSI005 4.4 Batch 5206396
 246 - (QC3- Inspect Part Finish)
 250 - (Assemble as per dwg) 1-Install Nut Plate as per Dwg D3274. Apply LPS-PROCYON to Nut Plate and rivets.
 260 - (QC5- Inspect part completeness to step on W/O) Inspect Nut Plate & Inserts

270 - (Assemble as per dwg) 1-Install wearpads as per Dwg D3274. 2-Install ring as per Dwg D3274 3-Inspect for foreign objects as per QSI 024 4-Install Aft Cap and seal with Sikaflex. Clean excess adhesive.

280 - (QC5- Inspect part completeness to step on W/O)

290 - (Identify as per dwg & Stock Location:) Location : FG073

295 - (Document Control) Photocopy bluefile & type labels per PPP D206-642- 541 CHG005

300 - (QC21- Final Inspection - Work Order Release) 4-Counterbore 5/16" x 0.750" deep as per Dwg D3274 using DT10280 and deburr.

Job BOM

013292

Part / Item	Component Name	Quantity	Operation	Container
D3274-041BENT	Skidtube Assembly 206	1 pcs (1 ea)	110-Skidtubes - 1	5216847
D3285-1	Cap	1 pcs (1 ea)	110-Skidtubes - 1	5233265
D3282-041	Float Web (206L/407)	1 pcs (1 ea)	150-Skidtubes - 2 - B4B	5210875
D2649	Cross Bolt Spacer	12 pcs (12 ea)	190-Skidtubes - 4 - B4B	5233402
D3275-1	Cross Bolt Spacer	12 pcs (12 ea)	190-Skidtubes - 4 - B4B	5213175
ALS4-1032-130	Rivnut	78 Ea (78 ea)	250-Handfinish - 4-1-Assembly-B4B	5057258-1
CCR264SS3-3	Cherry Rivet	2 Ea (2 ea)	250-Handfinish - 4-1-Assembly-B4B	5226161
CR3212-4-03	Cherry Rivet	2 Ea (2 ea)	250-Handfinish - 4-1-Assembly-B4B	5163230-3
D3415-041	Nut Plate	1 pcs (1 ea)	250-Handfinish - 4-1-Assembly-B4B	5218586
AN3C4A	Bolt	80 Ea (80 ea)	270-Handfinish - 4-2-Assembly-B4B	5220803-4
AN4C5A	Bolt	1 Ea (1 ea)	270-Handfinish - 4-2-Assembly-B4B	5225261
D2646	Aft Cap	1 pcs (1 ea)	270-Handfinish - 4-2-Assembly-B4B	5226755-2
D3413-1	O-Ring	1 pcs (1 ea)	270-Handfinish - 4-2-Assembly-B4B	5197616
D3537-1	Wearpad	9 pcs (9 ea)	270-Handfinish - 4-2-Assembly-B4B	5279457
D3537-3	Wearpad	1 pcs (1 ea)	270-Handfinish - 4-2-Assembly-B4B	5218982
D3672-1	Washer, Phenolic	2 pcs (2 ea)	270-Handfinish - 4-2-Assembly-B4B	F164008
D4956-15	Wearplate Fwd	1 pcs (1 ea)	270-Handfinish - 4-2-Assembly-B4B	5218063
D4956-23	Wearplate Center Fwd	1 pcs (1 ea)	270-Handfinish - 4-2-Assembly-B4B	5233472
D4956-35	Wearplate Aft	1 pcs (1 ea)	270-Handfinish - 4-2-Assembly-B4B	5209983
D4956-39	Wearplate Center Aft	1 pcs (1 ea)	270-Handfinish - 4-2-Assembly-B4B	5129202
NAS1149C0332R	Washer (AN960C10L)	80 Ea (80 ea)	270-Handfinish - 4-2-Assembly-B4B	5233309
NAS1149C0463R	Washer (AN960C416)	1 Ea (1 ea)	270-Handfinish - 4-2-Assembly-B4B	5104377

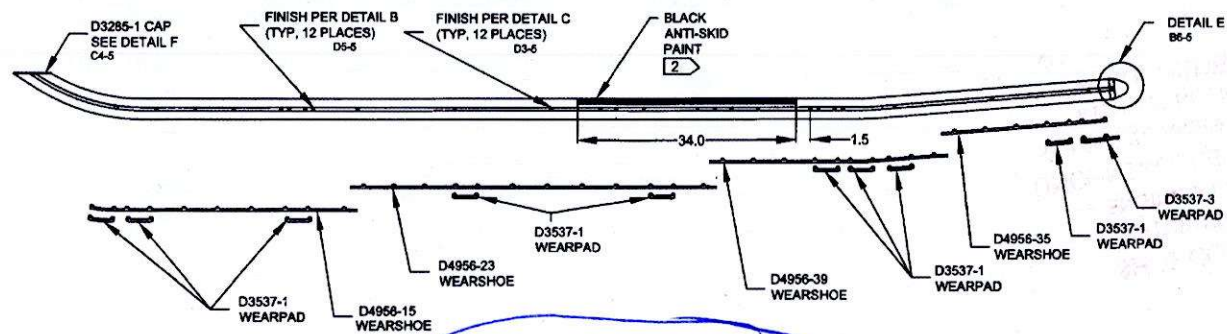
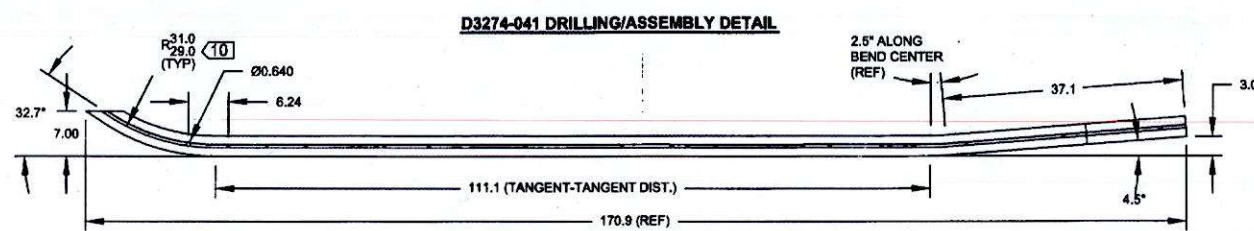
Job Allocations

013296

Operation	Component Part	Required	Inventory	Allocated
110-Skidtubes - 1	D3274-041BENT	1	8	0
	D3285-1	1	0	0
150-Skidtubes - 2 - B4B	D3282-041	1	4	0
190-Skidtubes - 4 - B4B	D2649	12	93	0
	D3275-1	12	218	0
250-Handfinish - 4-1-Assembly-B4B	ALS4-1032-130	78	4,866	0
	CCR264SS3-3	2	101	0
	CR3212-4-03	2	128	0
	D3415-041	1	43	0
270-Handfinish - 4-2-Assembly-B4B	AN3C4A	80	1,630	0
	AN4C5A	1	82	0
	D2646	1	29	0
	D3413-1	1	29	0
	D3537-1	9	74	0
	D3537-3	1	19	0
	D3672-1	2	1,195	0
	D4956-15	1	17	0
	D4956-23	1	4	0
	D4956-35	1	8	0
	D4956-39	1	14	0
	NAS1149C0332R	80	3,894	0
	NAS1149C0463R	1	151	0

Part Specifications

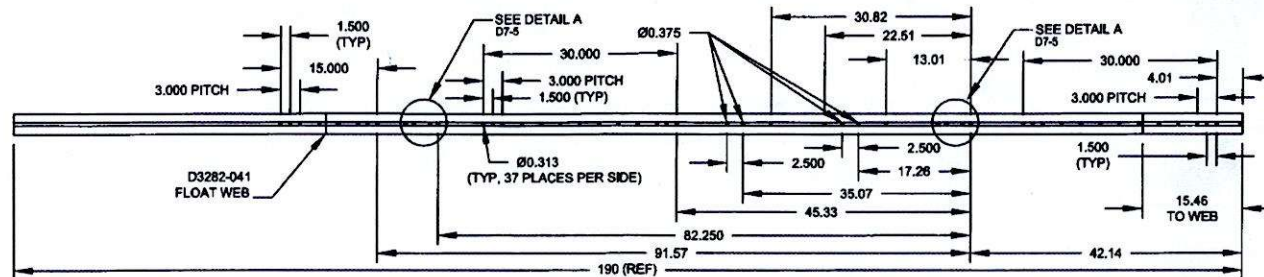
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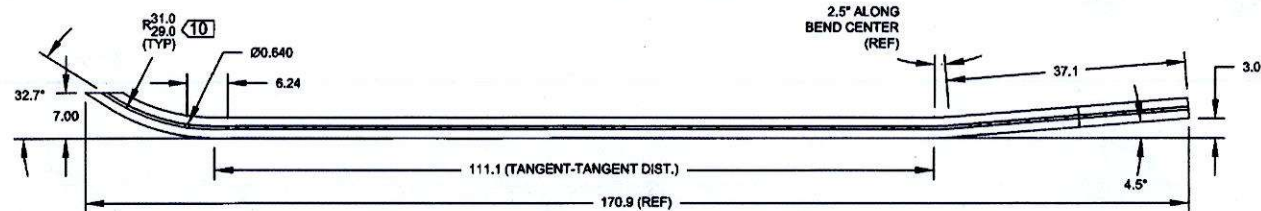
D3274-041 SKIDTUBE ASSEMBLY
(SEE DETAIL D FOR WEARSHOE INSTALLATION)

RELEASED
2016-07-26

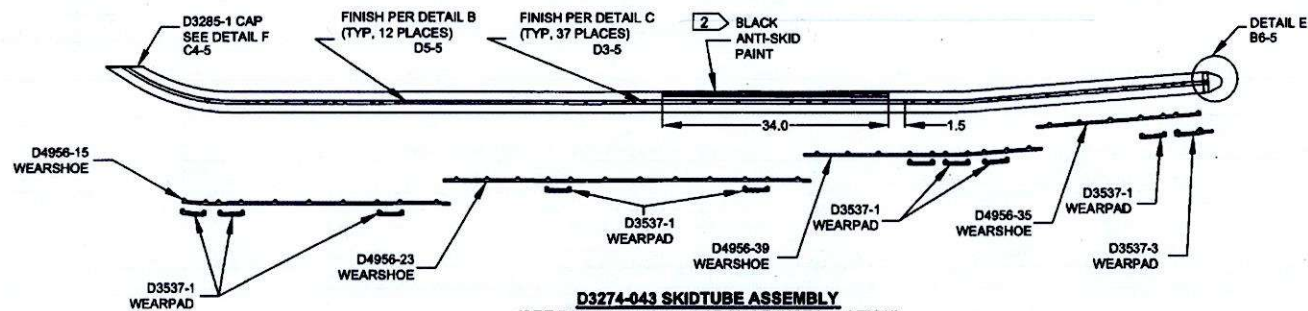
DESIGN	CP	DART AEROSPACE USA, INC	
DRAWN	RF	EUGENE, OR	
CHECKED	AK	DRAWING NO.	REV. G
MFG. APPR.	JLM	D3274	SHEET 2 OF 6
APPROVED	DS	TITLE	SCALE
DE APPR.		SKIDTUBE ASSEMBLY	NTS
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D3274-043 DRILLING/ASSEMBLY DETAIL



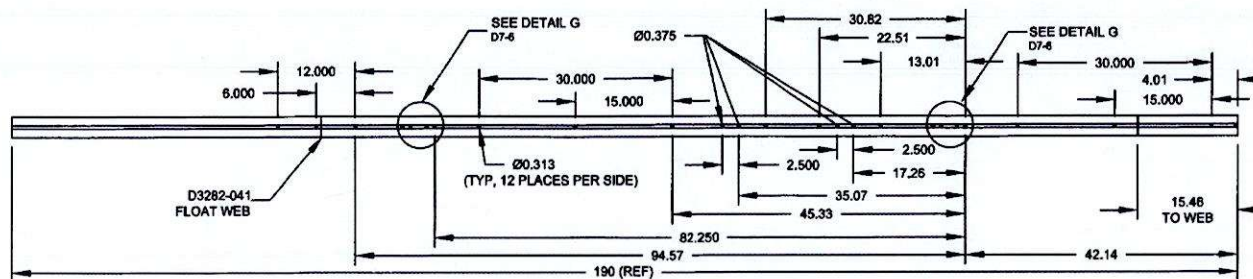
D3274-043 BEND/DRILLING DETAIL



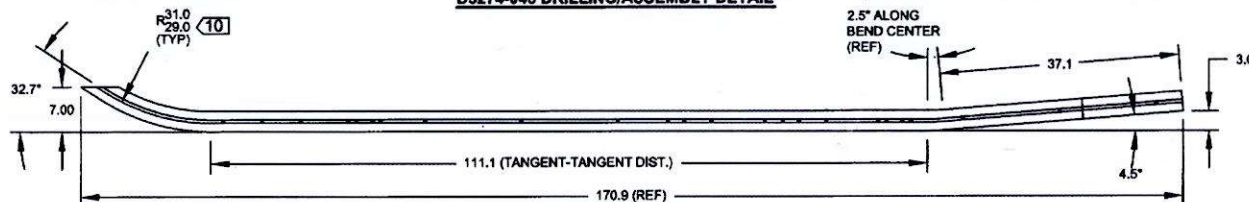
**D3274-043 SKIDTUBE ASSEMBLY
(SEE DETAIL D FOR WEARSHOE INSTALLATION)**

RELEASE
2016-07-26

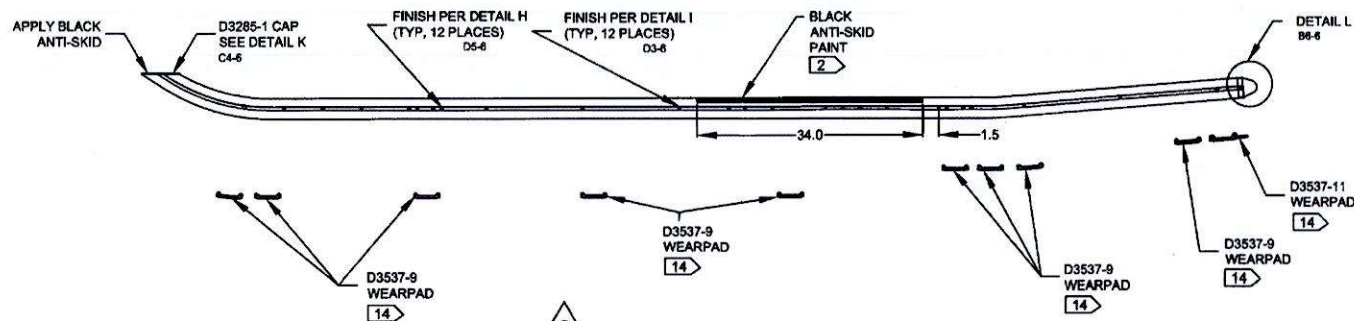
DESIGN	CP	DART AEROSPACE USA, INC	
DRAWN	RF	EUGENE, OR	
CHECKED	AK	DRAWING NO.	REV. G
MFG. APPR.	JLM	D3274	SHEET 3 OF 6
APPROVED	DS	TITLE	SCALE
DE APPR.	DS	SKIDTUBE ASSEMBLY	NTS
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D3274-045 DRILLING/ASSEMBLY DETAIL



D3274-045 BEND/DRILLING DETAIL

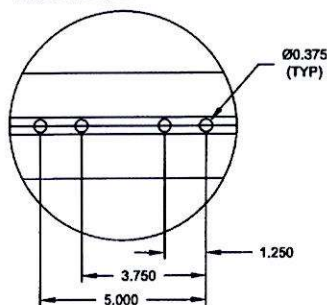


D3274-045 SKIDTUBE ASSEMBLY
(SEE DETAIL J FOR WEARSHOE INSTALLATION)

RELEASED
2016-07-26

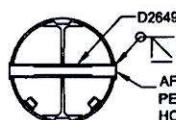
DESIGN	CP	DART AEROSPACE USA, INC	
DRAWN	RF	EUGENE, OR	
CHECKED	AK	DRAWING NO.	REV. G
MFG. APPR.	JLM	D3274	SHEET 4 OF 6
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DE APPR.		SKIDTUBE ASSEMBLY	NTS
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DETAIL A: DRILL DETAIL
D6-2, D3-2, D5-3, D3-3



DETAIL B
B6-2, B5-3

FOR Ø0.375 HOLES ONLY

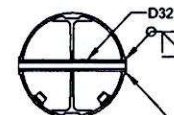


D2649 SPACER

- AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.375
HOLES ONLY:
1. CHAMFER HOLE 0.030x45°
 2. INSERT D2649 SPACER
 3. WELD INTO PLACE AND GRIND FLUSH
 4. C'BORE TO Ø0.313x0.75 DEEP

DETAIL C
B5-2, B4-3

FOR Ø0.313 HOLES ONLY



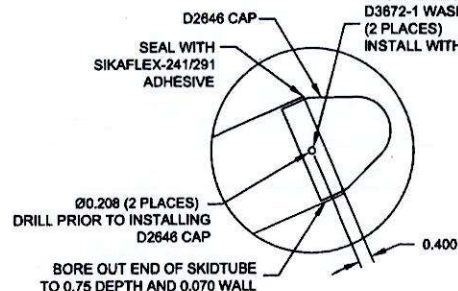
D3275-1 SPACER
CHAMFER 0.030x45°
(TYP)

DETAIL D
A4-2, A4-3



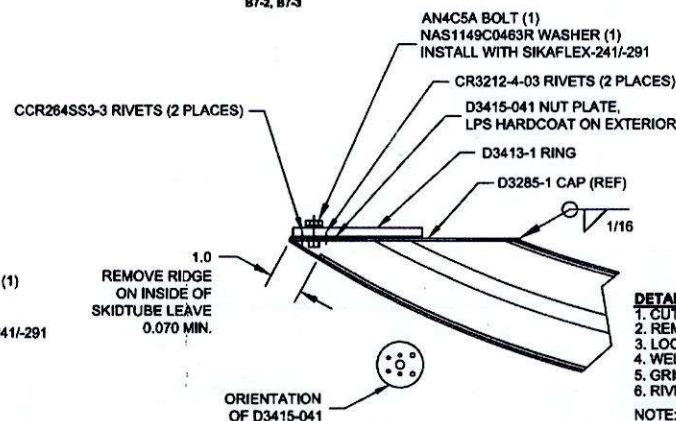
- ALS7-1032-130 INSERT (1)
AN3C4A BOLT (1)
NAS1149C0332R WASHER (1)
(78 PLACES)
WEARSHOE/WEARPAD (REF) G

DETAIL E
B2-2, B2-3



- AN3C4A BOLT (1)
NAS1149C0332R WASHER (1)
D3672-1 WASHER (1)
(2 PLACES)
INSTALL WITH SIKAFLEX-241/291

DETAIL F: END FINISHING DETAIL
B7-2, B7-3



DETAIL F NOTES

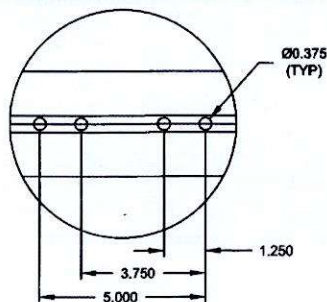
1. CUT TUBE LEVEL
 2. REMOVE RIDGE ON FWD SIDE
 3. LOCATE D3285-1 (TRIM AS NECESSARY)
 4. WELD D3285-1 IN PLACE PER DART QSI 004
 5. GRIND FLUSH
 6. RIVET D3415-041 NUT PLATE IN PLACE
- NOTE: MASK THREADS IN D3415-041
PRIOR TO FINISH

-041/-043 DETAILS

RELEASED
2016-07-26

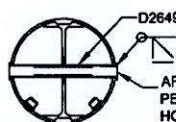
DESIGN	CP	DART AEROSPACE USA, INC	
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CHECKED	AK	DRAWING NO.	REV. G
MFG. APPR.	JLM	D3274	SHEET 5 OF 6
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DE APPR.		SKIDTUBE ASSEMBLY	NTS
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DETAIL G: DRILL DETAIL
D8-4, D3-4



DETAIL H
B6-4

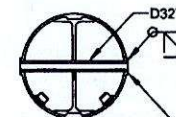
FOR Ø0.375 HOLES ONLY



- AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.375
HOLES ONLY:
1. CHAMFER HOLE 0.030x45°
 2. INSERT D2649 SPACER
 3. WELD INTO PLACE AND GRIND FLUSH
 4. C'BORE TO Ø0.313x0.75 DEEP

DETAIL I
B5-4

FOR Ø0.313 HOLES ONLY



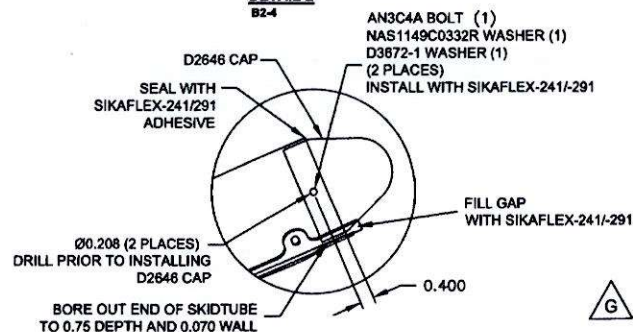
CHAMFER 0.030x45°
(TYP)

DETAIL J
A4-4

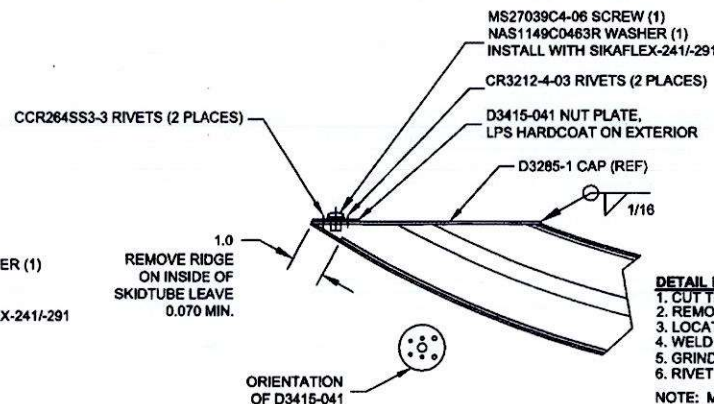


- ALS7-1032-130 INSERT (1)
AN3C4A BOLT (1)
NAS1149C0332R WASHER (1)
(40 PLACES)
WEARPAD (REF)

DETAIL L
B2-4



DETAIL K: END FINISHING DETAIL
B7-4



DETAIL K NOTES

1. CUT TUBE LEVEL
 2. REMOVE RIDGE ON FWD SIDE
 3. LOCATE D3285-1 (TRIM AS NECESSARY)
 4. WELD D3285-1 IN PLACE PER DART QSI 004
 5. GRIND FLUSH
 6. RIVET D3415-041 NUT PLATE IN PLACE
- NOTE: MASK THREADS IN D3415-041
PRIOR TO FINISH

G -045 DETAILS

RELEASED
2016-07-26

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MFG. APPR.	JLM	D3274	SHEET 6 OF 6
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DE APPR.		SKIDTUBE ASSEMBLY	NTS
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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					